

ASAP

Date: Monday, 10/22/2007 3:41:41 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 35282		
Estimate Number	: 10416		
P.O. Number	:	Part Number	: D31981
This Issue	: 10/22/2007 S.O. No. :	Drawing Number	: D3198 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 31467	Material	:
Written By	:	Due Date	: 11/5/2007
Checked & Approved By	: <u>107.10.23</u>	Qty:	15 Um: Each
Comment	Est: A 03.11.11 New Issue KJ/RF Est Rev:B Now on Waterjet 07-01-09 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.1103 sf(s)/Unit Total : 1.3230 sf(s)

304/316 .125 Sheet

Batch: 104934 IB 07-10-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3198

Dwg Rev: A

Prog Rev: A

IB 07-10-23

2-Deburr if necessary

IB 07-10-24

(18) 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-10-23

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IB 07/10/24 (120) com

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D3198

IB 07/10/25 (20)  
IB 07/10/29 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 10/22/2007 3:41:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 35282

Part Number: D31981

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counters*  
*See 07/11/01* *(x20)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M105642*

*BR 07-10-31* *(20)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*07/11/01*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST243*

*07/11/01*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07.11.01* *AG*

Job Completion



*U 07-11-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

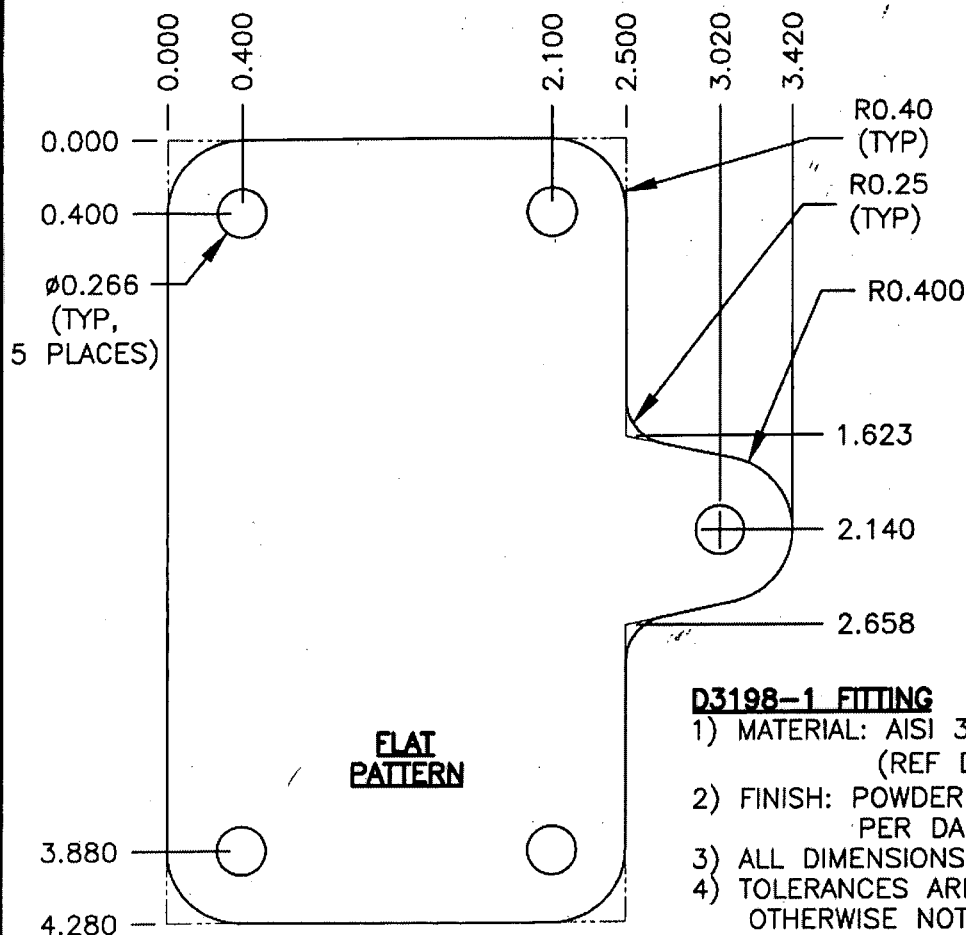
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





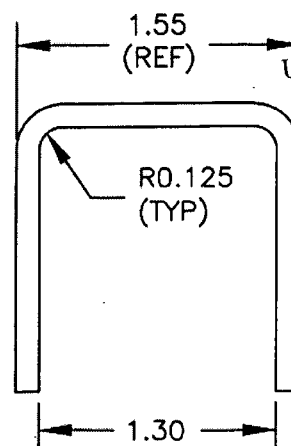
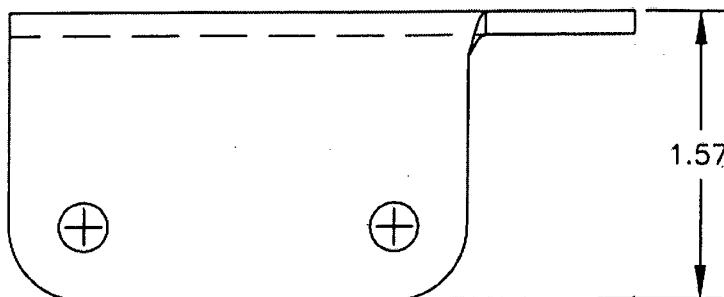
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	



#### D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED  
03.10.10 *#*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35282  
**BEND  
DETAIL**

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